MULTISTRETCH 336-6/7 MOTOR CONTROL BOARD CALIBRATION INSTRUCTION

<u>Bias:</u> (RV3) The potentiometer labeled RV3 controls the system bias.

This control injects an offset voltage which adds or subtracts from the voltage reference defined by the external tension adjustment (film tension potentiometer); this will allow extremes of adjustment to be set to levels consistent with proper operation. Typically, the bias will be used to center the operation range in the linear portion of its characteristics.

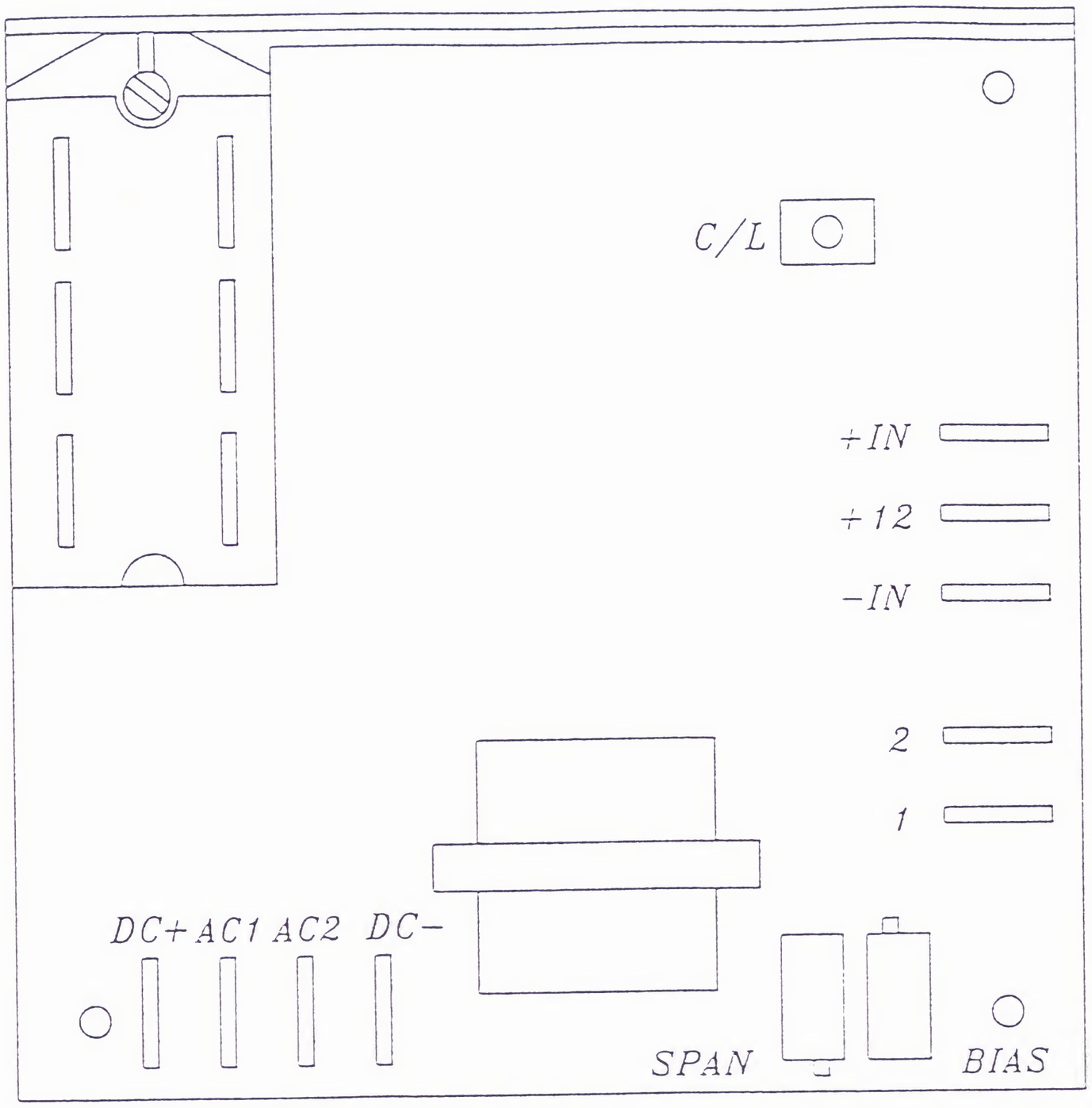
***Note:** This adjustment is normally factory pre-set and should not require field adjustment.*

<u>Span:</u> (RV1) The potentiometer labeled RV1 controls the system loop gain.

The system loop gain may be adjusted if the motor continues to be energized when the dancer roller is unloaded and at rest. With the machine stopped, the potentiometer should be adjusted to ensure that the motor is de-energized in this condition, and so that a light pull on the free end of the film causes the film to feed freely. Counter clockwise (CCW) adjustment of this potentiometer will increase the response time, in effect soften the motor tension response plus decrease the maximum motor speed attainable. Clockwise (CW) adjustment of this potentiometer will decrease the response time, in effect sharpen the motor response plus increase the maximum motor speed attainable.

<u>Current Limit:</u> (RV4) The potentiometer labeled RV4 controls the torque (amperage) that the 336 board will allow to the motor.

To protect the unit against damage, should the motor stall, jam, or current demands exceed its rating, a current limiting circuit is included which keeps motor current at a safe level regardless of motor load or input from the hall effect proximity switch. This potentiometer is factory pre-set to suit 1/2 hp motors. Should changes be required in the field, proceed as follows: Monitor the motor current. Turn the current limit (RV4) to minimum (full CCW). Stall the motor. Advance the potentiometer slowly until the desired current is achieved. This should not exceed 125% of the motor name plate rating. Do not stall the motor for more than a few seconds, or damage may occur.



DC+: ARMATURE CONTROL

DC-: ARMATURE CONTROL

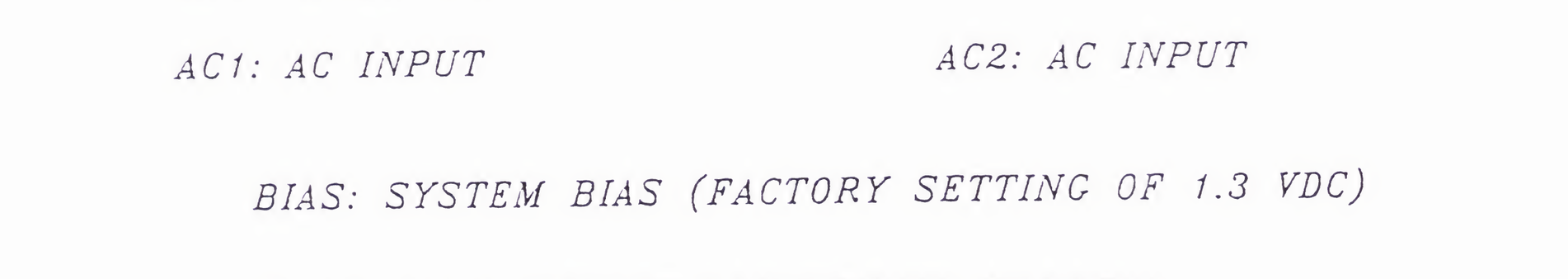
AC1: AC INPUT

AC2: AC INPUT

BIAS: SYSTEM BIAS (FACTORY SETTING OF 1.3 VDC)

SPAN: HALL EFFECT SENSITIVITY CONTROL

FILM TENSION ADJUSTMENT
REMOTE POTENTIOMETER



336-6/7 MULTISTRETCH SCR BOARD

336-7.DWG